

**Work Order ID 81608****\*81608\***

Page 1

March-16-12 7:44:50 AM

Item ID: D412-761-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Large Bubble Window, LH

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *12/03/16*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-761

Rev D

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D412-761-045 CHG001

*h*  
*Sizbeliz**MLJ 12/03/16**(2)*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*SP 12-03-22*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*Sizbeliz**(40)**✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81608****\*81608\***

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March-16-12 7:44:50 AM

Item ID: D412-761-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Large Bubble Window, LH

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-761-045

Location: 115

PPP Rev: \_\_\_\_\_

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*12/4/12 (2)**12/4/12**12-01-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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• March-16-12 7:44:55 AM

Work Order ID: 81608

Parent Item: D412-761-045

Parent Item Name: Large Bubble Window, LH

\*81608\*

\*D412-761-045\*

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3704-3		Manufactured	No			110	Each	3.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D3704-3\*

Escutcheon

Location

Loc Qty

Loc Code

ST075

3

56880

3

D412-761-043

CH701

Manufactured	No			110	Each	1.0000	1	2				
--------------	----	--	--	-----	------	--------	---	---	--	--	--	--

\*D412-761-043\*

Modified Latch Mechanism, LH

Location

Loc Qty

Loc Code

FG033

1

79138

1

D3676-1

Manufactured	No			110	Each	0.0000	1	2				
--------------	----	--	--	-----	------	--------	---	---	--	--	--	--

\*D3676-1\*

Bubble Window, LH

D3678-1

Manufactured	No			110	Each	11.0000	1	2				
--------------	----	--	--	-----	------	---------	---	---	--	--	--	--

\*D3678-1\*

Placard

Location

Loc Qty

Loc Code

ST060

11

46354

11

D3678-3

Manufactured	No			110	Each	11.0000	1	2				
--------------	----	--	--	-----	------	---------	---	---	--	--	--	--

\*D3678-3\*

Placard

Location

Loc Qty

Loc Code

ST060

11

46355

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-16-12 7:44:55 AM

Work Order ID: 81608

\*81608\*

Parent Item: D412-761-045

\*D412-761-045\*

Parent Item Name: Large Bubble Window, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3700-1

Manufactured No

110 Each

2.0000

1 2

\*D3700-1\*

Inboard Window Doubler

\*\*

SP 1x 82783

Location

Loc Qty

Loc Code

ST061

2

54803

1

58839

1

D3700-3

Manufactured No

110 Each

2.0000

1 2

\*D3700-3\*

Outboard Window Doubler

\*\*

SP 82784

Location

Loc Qty

Loc Code

ST196

2

54804

2

D3701-1

Manufactured No

110 Each

1.0000

1 2

\*D3701-1\*

Floor Doubler

\*\*

SP 82785

Location

Loc Qty

Loc Code

ST196

1

56694

1

D3702-1

Manufactured No

110 Each

4.0000

1 2

\*D3702-1\*

Low Doubler

\*\*

SP 12-03-22

Location

Loc Qty

Loc Code

ST196

4

54806

2

58840

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 81608

Parent Item: D412-761-045

Parent Item Name: Large Bubble Window, LH

\*81608\*

\*D412-761-045\*

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3703-1 Manufactured No

110 Each

7.0000

1

2

\*\*

\*D3703-1\*

Aft Doubler

Location

Loc Qty

Loc Code

ST196

7

56695

7

D3703-3 Manufactured No

110 Each

2.0000

1

2

\*\*

\*D3703-3\*

Aft Corner Doubler

Location

Loc Qty

Loc Code

ST078

2

54808

2

D3703-5 Manufactured No

110 Each

9.0000

1

2

\*\*

\*D3703-5\*

Aft Cap

Location

Loc Qty

Loc Code

ST061

9

54809

9

D3704-1 Manufactured No

110 Each

7.0000

1

2

\*\*

\*D3704-1\*

ESCUTCHEON

Location

Loc Qty

Loc Code

ST061

7

56330

2

56696

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

March-16-12 7:44:56 AM

Work Order ID: 81608

\*81608\*

Parent Item: D412-761-045

\*D412-761-045\*

Parent Item Name: Large Bubble Window, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3708-1

Manufactured No

110 Each

5.0000

1

2

\*D3708-1\*

Angle

\*\*

Location

Loc Qty

Loc Code

ST196

5

56697

5

D3708-3

Manufactured No

110 Each

5.0000

1

2

\*D3708-3\*

Angle

\*\*

Location

Loc Qty

Loc Code

ST196

5

56698

5

D3709-1

Manufactured No

110 Each

16.0000

1

2

\*D3709-1\*

Angle

\*\*

Location

Loc Qty

Loc Code

ST196

16

54814

9

56699

7

D3709-3

Manufactured No

110 Each

10.0000

1

2

\*D3709-3\*

Angle

\*\*

Location

Loc Qty

Loc Code

ST196

10

54815

2

56700

8

B548121X

2X

8P

2X

8P

2X

8P

2X

8P 12-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-16-12 7:44:56 AM

Work Order ID: 81608

\*81608\*

Parent Item: D412-761-045

\*D412-761-045\*

Parent Item Name: Large Bubble Window, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3802-1 Manufactured No

110 f 104.7500 13.5 27

\*D3802-1\*

Window Seal

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST412

104.75

56881

4.75

81021

100

27

1- Cut one per dwg d3802-1-135

DT9458

Manufactured No

110 Each

0.0000

1

2

\*DT9458\*

Cutting Template

\*\*

AN3-7A

Purchased No

110 Each

147.0000

26

52

\*AN3-7A\*

Bolt

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST351

147

117872

147

52x

AN960JD10

NAS1149D0363J

Purchased No

110 Each

0.0000

52

104

\*AN960JD10\*

Washer

\*\*

M/20308 SP

MS21042L3

Purchased No

110 Each

3,091.000

26

52

\*MS21042L3\*

Nut

\*\*

SP 12-03-22

## Location

## Loc Qty

## Loc Code

ST300

3091

117441

16

117885

32

118451

5

118927

3

119017

2862

119075

173

52x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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March-16-12 7:44:56 AM

Work Order ID: 81608

\*81608\*

Parent Item: D412-761-045

\*D412-761-045\*

Parent Item Name: Large Bubble Window, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS24694-C5

Purchased

No

110

Each

65.0000

1

2

\*MS24694-C5\*

Screw

\*\*

Location

Loc Qty

Loc Code

ST289

65

106815

65

MS24694-C13

Purchased

No

110

Each

42.0000

1

2

\*MS24694-C13\*

Screw

\*\*

Location

Loc Qty

Loc Code

ST289

42

108558

42

SP

2x

SP 12-03-22

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH
	1				D3589-041	LATCH ASSEMBLY
	1				D3589-047	FORWARD GUIDE
	1				D3589-049	AFT GUIDE
	2				MS16997-22	SCREW
	2				AN960JD6L	WASHER
	2				MS21042L06	NUT
		1			D3676-1	LARGE BUBBLE WINDOW
		1			D3678-1	PLACARD
		1			D3678-3	PLACARD
		1			D3700-1	INBOARD WINDOW DOUBLER
		1			D3700-3	OUTBOARD WINDOW DOUBLER
		1			D3701-1	FLOOR DOUBLER
		1			D3702-1	FORWARD DOUBLER
		1			D3703-1	AFT DOUBLER
		1			D3703-3	AFT CORNER DOUBLER
		1			D3703-5	AFT CAP
		1			D3704-1	ESCUTCHEON
		1			D3704-3	ESCUTCHEON
		1			D3708-1	ANGLE
		1			D3708-3	ANGLE
		1			D3709-1	ANGLE
		1			D3709-3	ANGLE
		1			D3802-1-135	SEAL
		1			DT9458	CUTTING TEMPLATE
		26			AN3-7A	BOLT
		52			AN960JD10	WASHER
		26			MS21042L3	NUT
		1			MS24694-C5	SCREW (OR MS24694-S5)
		1			MS24694-C13	SCREW (OR MS24694-S13)
			1		D3705-041	INSTRUMENT PANEL ASSEMBLY
			1		D3705-043	* INSTRUMENT PANEL WELDMENT
			1		D3335-1	* SPRING
			1		D3705-5	* ACCESS PANEL
			1		D3706-5	* PIN
			2		D3707-3	* MOUNTING LUG
			4		AN526C1032R6	* SCREW
			1		AN960JD516	* WASHER
			1		MS171498	* SPRING SLOTTED PIN
			4		MS24693-C272	* SCREW (OR MS24693-S272)

\*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 9)

(CONTINUED FROM PAGE 8)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
			2		D3707-1	MOUNTING LUG
			1		D3790-1	INDEXING BLOCK
			1		D3867-1	CONNECTOR PLATE
			4		AN3-3A	BOLT
			6		AN526C1032R6	SCREW
			2		AN743-12	BRACKET
			6		AN960JD10L	WASHER
			6		MS21075L3	NUTPLATE (OR MS21073-3)
			4		MS24693-C272	SCREW (OR MS24693-S272)
			1		MS27039-1-17	SCREW
			1		MS27039-1-27	SCREW
			4		MS21042L3	NUT
			2		MS21919WDG8	CLAMP
				1	<b>D3694-041</b>	<b>MOUNTING PLATE ASSEMBLY</b>
				1	D3694-1	* KEYWAY
				1	D3694-3	* PROTECTIVE PLATE
				1	D3694-5	* MOUNTING PLATE
				1	AN526C1032R8	* SCREW
				5	AN960JD10	* WASHER
				4	MS21042L3	* NUT
				2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				1	MS24693-C271	* SCREW (OR MS24693-S271)
				4	MS24693-C273	* SCREW (OR MS24693-S273)
				1	<b>D3695-041</b>	<b>SLIDER ASSEMBLY</b>
				1	D3695-1	* SLIDER
				1	D3695-3	* STOPPER
				1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
				1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
				4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				4	MS24693-C276	* SCREW (OR MS24693-S276)
				1	<b>D3780-041</b>	<b>ARMREST ASSEMBLY</b>
				1	D3696-041	* ARM ASSEMBLY
				1	D3696-1	** ARM
				1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
				1	D3781-041	* LATERAL CUSHION ASSEMBLY
				1	D3781-043	* ARMREST CUSHION ASSEMBLY
				1	D3785-3	* BRACKET
				1	D3977-1	* BOLT
				1	D3978-1	* NUT (CASTELLATED)
				1	D3979-1	* WASHER (SQUARE HOLE)
				2	AN970-6	* WASHER
				1	MS24665-302	* COTTER PIN
				2	MS21042L3	* NUT
				2	MS24693-C272	* SCREW
				2	MS24693-C277	* SCREW
				1	NAS1149D0663J	* WASHER

\* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

\*\* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 10)

(CONTINUED FROM PAGE 9)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
				11	AN3-6A	BOLT
				1	AN6-26	BOLT
				1	AN310-6	CASTELLATED NUT
				11	AN960JD10	WASHER
				1	AN960JD616L	WASHER
				2	NAS1515H6L	WASHER
				1	MS24665-302	COTTER PIN
				3	MS21071L3	ANCHORNUT
				8	MS21075L3	NUTPLATE

**6.0 PARTS LIST, OPTIONAL VENT KIT**

QTY -141	PART NUMBER	DESCRIPTION
X	D412-761-141	VENT KIT
4	D3932-1	SNAP VENT